

2014 Annual Green Tier 1 Report

**The Toro Company
200 Sime Avenue
Tomah, WI 54660**

Background:

The Toro Company – Tomah, Wisconsin facility received formal approval into the Wisconsin DNR Green Tier 1 program on June 29, 2012. The Toro Company in Tomah, WI manufactures both landscape contractor and commercial turf care products and service parts. The facility currently employs over 600 people at a 300,000 square foot facility.

Environmental Management System (EMS)

The Toro Company received ISO 14001 environmental certification renewal on October 18, 2014. In May 2014, Toro received re-certification on its 1st surveillance audit after re-certification through LRQA (Lloyd's Register Quality Assurance, Inc.).

Environmental Compliance:

External auditors complete environmental compliance audits of Toro-Tomah every three years. The next scheduled compliance audit is January 2015. The last audit in 2012 has shown that the facility meets environmental compliance requirements. A few minor items were identified in the 2012 audit. Identified items have been corrected to meet requirements.

Environmental Targets and Objectives:

1) Improve Waste Management

- a. Continue recycling for aluminum cans and plastics. Continue to reduce material being sent to landfill.**

Year	Wood	Cardboard	Metal	Landfill
F13 (Actual)	1,664,000	704,700	498,160	172,500
F12 (Actual)	1,728,000	939,000	405,160	230,000
F11 (Actual)	1,552,000	783,000	600,460	368,000
F10 (Actual)	1,216,000	665,000	457,520	494,500

***Changed to returnable packaging**

Recycling efforts have reduced material send to landfill by 33% from 2012 to 2013.

- b. Visit, tour, and audit one transporter and/or disposal facility of hazardous waste annually.**
Facility audit scheduled for later this year.
- c. Evaluate the application and use of “True Blue” water recycling and/or other wastewater treatment process to reduce phosphorus levels below 20 ppm on Toro’s Ecoat wastewater system and allows reuse of water. Determine feasibility of equipment use by quantifying reductions in wastewater, sludge disposal, and wastewater treatment costs with proposed equipment.**
Currently under investigation
- d. Eliminate/replace the use of MEK for use in cleaning/flushing paint guns and hoses with a “non-listed” solvent. Evaluate alternate solvents to determine cleaning effectiveness and waste characterization.**
All MEK related materials have now been eliminated from use in the plant. The replacement gun flush solvent is in use and has been found effective.
- e. Reduce hazardous waste by a minimum of 80%. Hazardous waste can potentially be reduced through the elimination of MEK for paint cleaning.**
 - 1. Testing and waste stream profile completed. Lacquer thinner has been determined to allow reclassification of paint waste in solid form from hazardous waste to special non-hazardous waste. Lacquer thinner in solid state no longer contains characteristics of a hazardous waste.
 - 2. Waste has been re-characterized as a non-hazardous waste.
- f. Pursue an electronics recycling day for Toro employees and local community. This activity will assist the community with reduction of potential waste entering landfills. All proceeds to benefit Monroe County Crime Stoppers.**
 - 1. E-waste collection to completed in conjunction with Monroe County Crime Stoppers on 5/3/14.

2) Improve Chemical Management

- a. Develop a BMP for mercury.**
BMP and mercury containing device inventory has been completed.
- b. Support purchase, installation, start up, and operation of new Tractor paint finishing system.**
 - 1. Tractor washer has been installed during the month of December 2014 and operational by January 4, 2014.

2. **Evaluate alternatives to chromium seal. Evaluate the elimination of chrome from the Tomah plant with a polymer based product.**

Currently under test and evaluation. Final determination based on Tractor paint equipment selection.

c. **Evaluate reductions in natural gas, electrical, and water usage resulting in reduced costs associated with replacement of Tractor washer.**

1. Actual cost saving

a. Water: \$63,899.00

b. Natural gas: \$24,303.00

c. Electrical \$22,008.00

Total Savings \$110,202.00/Year

3) **Improve Environmental Management**

a. **Investigate need to modify current regulatory permitting with inclusion of new product lines and capital equipment purchases.**

1. Air permit is currently under review and will be ready for submission by October 2014.

b. **Provide refresher training in the following areas;**

All training is current and up to date.

Executive Summary:

From advanced work in electric, biofuel, and propane technologies to our many water-saving irrigation products, we are committed to protecting the world's critical resources and delivering commercially viable solutions that yield environmental, performance, and productivity innovation to our customers.

Equally important are our ongoing efforts to create a leaner, more efficient operational footprint. Across all worldwide manufacturing facilities, we recycle steel, aluminum, plastics and cardboard packaging. To reduce wood packaging waste, we ship many of our professional products as drive-on products and receive many of our product components from suppliers in reusable packaging. We recycle water and reuse paint within our paint systems. We also continue to invest in more advanced technologies that allow us to reduce our energy usage and improve productivity.

Environmental Performance:

1. This past year Toro continues to make design changes to its products to meet TIER IV EPA emission compliance.
2. Toro has installed a water recycling system to allow reuse over 1,000,000 gallons of water each year.

3. Toro has installed a new paint finishing system resulting in a reduction of water and energy.